

Work Order ID 92957-2

November-12-12 1:37:08 PM

92957

Page 1

Item ID: D4635-3

Accept

Revision ID:

N9000040100

Item Name: Aft Ceiling Panel, LH

Setup Start

NS1

Start Date: 12/11/2012 Start Qty: 2.00

2

Stop

NS2

Required Date: 12/12/2012 Req'd Qty: 2.00

2

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan: MLJ

Date: 12-11-12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID:

Operation

Set

ID

Plan

Code

Accept

Qty

Re

Insp.

D4635

A Rev B 12/13/18

100

0.00

100

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x2

12/12/04

105

0.00

105

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°F

Time IN: 7:00 pm 12/12/03

Time OUT: 7:00 am 12/12/04

x2

12/12/04

Work Order ID 92957

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Page 2

Item ID: D4635-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Ceiling Panel, LH

Start Date: 12/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

110

0.00

110

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D4635-3 and Folio FTA149

Dwg. Rev. A

Folio Rev. A

Visually inspect for proper formation and texture

X2

17/10/04

130

0.00

130

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

X1

BB 13/03/20

140

0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

X1

BB 13/03/20

Work Order ID 92957

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Item ID: D4635-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Ceiling Panel, LH

Start Date: 12/11/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

DAS
16
13/03/20

150

QC

Memo

0.00

Quality Control

location

MEOTAB 13/03/25

160

Packaging

0.00

160

Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

13/3/27

MF
13-3-26

Picklist Print

November-12-12 1:37:12 PM

Page 1

Work Order ID: 92957

92957

Parent Item: D4635-3

D4635-3

Parent Item Name: Aft Ceiling Panel, LH

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	1,028.362	8.49	18.86667			

MKYD6185S 080-P3-62015

6185 KYDEX .080"

**

Wh
12/12/10

Location

therm

Loc Qty

1028.362377

Loc Code

116576

14.148377

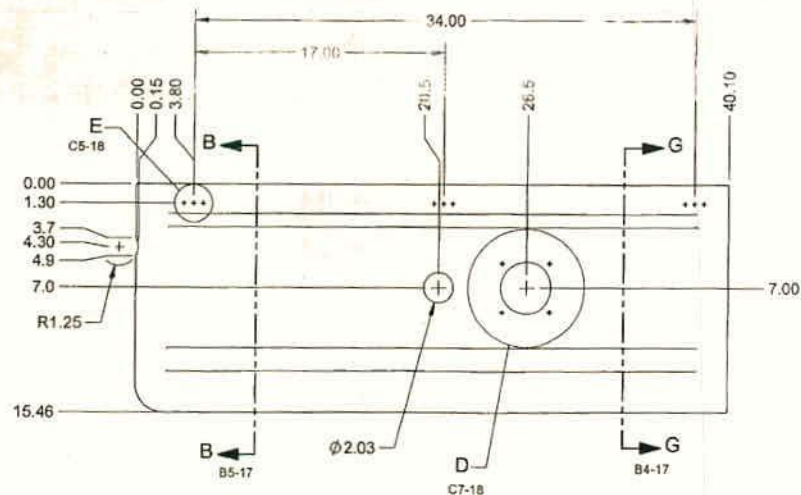
121755

1014.214

18.9759 P4



SECTION H-H B2-15



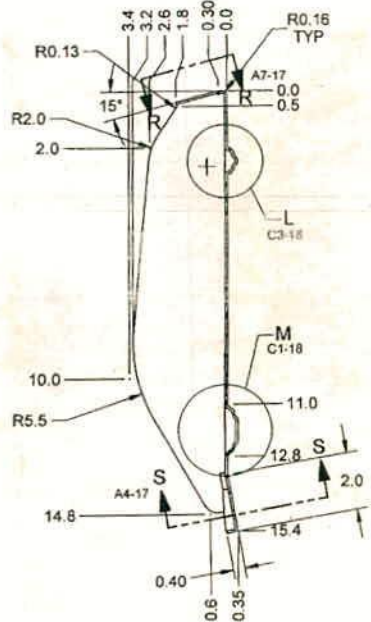
NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,
P3-VELOUR MATTE, STEEL GRAY #52068
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.60 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-3 PER TOOL DT9841
- 10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL
MIN. THICKNESS AFTER FORMING:
RIDGES/EDGES = 0.060
ELSEWHERE = 0.070

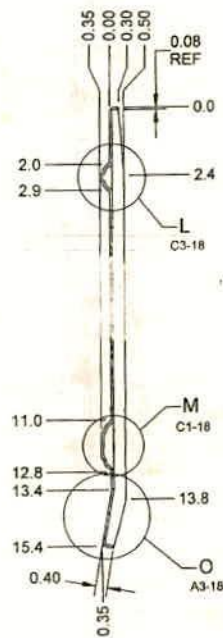
D4635-3 LH, AFT CEILING PANEL

RELEASE
2013-01-30
MP

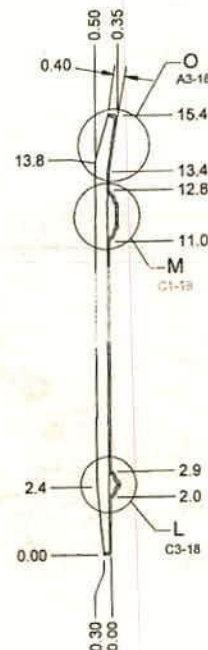
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. 8
MFG. APPR.	RF	D4635	SHEET 15 OF 18
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD CEILING PANELS	NTS
DATE	12.11.30	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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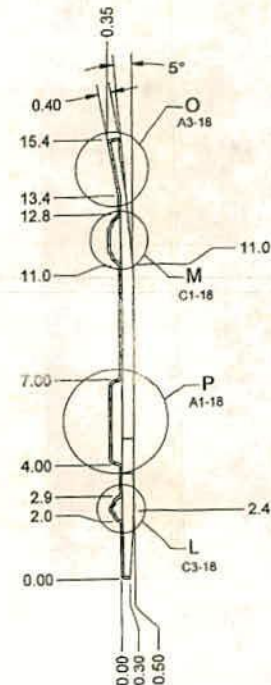
SECTION A-A
SECTION A-A' OPPOSITE
SCALE 2X



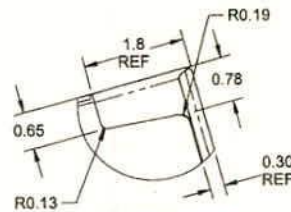
SECTION B-B
SCALE 2X



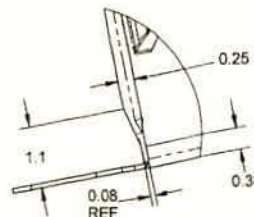
SECTION G-G
SCALE 2X



SECTION K-K
SCALE 2X



AUXILIARY VIEW R-R
SECTION R-R' OPPOSITE
SCALE 2X



AUXILIARY VIEW S-S
SECTION S-S' OPPOSITE
SCALE 2X

RELEASED
2013-01-30


DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4635	SHEET 17 OF 18
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DART AEROSPACE LTD		Work Order: 92957
Description: 139 LH Aft Ceiling Panel		Part Number: D4635-3
Inspection Dwg: 4635	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: 	Date: 13/03/20
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
40.10	.030	40.060			TH-05	
15.46	.030	15.430			TH-05	
1.30	.030	1.304			DL-02	
3.80	.030	3.80			DL-02	
17.00	.030	17.00			TH-05	
34.00	.030	34.00			TH-05	
20.50	.100	20.55			TH-05	
26.5	.100	26.5			TH-05	
7.00	.030	7.00			TH-05/TH-06	
2.03	.030 2.019	2.019			DL-02	
3.50	.030	3.52			DL-02	

Measured by: 	Date: 13-03-20
Audited by:  13/03/20	Date:
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

DART AEROSPACE LTD		Work Order: 92957
Description: 139 LH AFT CEILING PANEL		Part Number: D4635-3
Inspection Dwg: 4635	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by:	Date:
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.30	.030	.31			DC-02	
.50	.030	.52			DC-02	
.40	.030	.41			DC-02	
2.4	.100	2.4			TH-05	
13.8	.100	13.8			TH-05	
.060	Min	.067			DC-02	
.070	Min	.073			TH-DM	

Measured by: <i>JB</i>	Date: 13-03-20
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Audited by: <i>S 13/03/20</i>	Date:
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14